

29

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>20958</b>
<b>Description:</b> Bearpaw Kit (19" x 24")	<b>Part Number:</b>	<b>K10008</b>
<b>Dwg:</b> D2432 Rev. F3	<b>Qty:</b>	<b>10 Kits</b>
<b>Ref:</b> K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler <b>Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required</b>	HA	04.06.01	10																																																
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 <b>(Bag Bluefiles separately)</b>	HA WK 25kg PH	04.06.29 04.07.07	10 10 <del>10</del>																																																
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: <u>M15075</u>	EP	04/07/16	10																																																
4	MV	Inspect material for defects or damage prior to machining	EP	04/07/16	10																																																
5	MV	Machine as per Folio D2432 and Dwg D2432 <b>Identify as D2432F</b>	EP	04/07/20	10																																																
6	QC2	Inspect parts as they come off the CNC machine	EP	04/07/20	10																																																
7	MV	Deburr	EP	04/07/20	10																																																
8	QC8 & 5	Second inspection	EP	04.07.23	10																																																
9	KP	<b>Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3)</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B20927</td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B20958</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B20387</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B20388</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B20433</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>M14544</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>M14311</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>M15020</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M14764</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B20434	12	D2274	Radius Block	B20927	2	D2432F	24" Bearpaw	B20958	6	D2438	Clamp	B20387	12	D2529	Washer	B20388	6	D2732-050	Rubber Cushion	B20433	12	AN4-15A	Bolt	M14544	12	AN4-17A	Bolt	M14311	24	AN960JD416	Washer	M15020	12	MS21042L4	Nut (or -4)	M14764	1	Paperwork package from Step 2					
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10	QC4	Inspect Kit for 100% Completeness on the W/O	CL	04/07/28	10																																																
11	PK	Identify and pack for shipping as per PPP K10008	REV. E	04/08/03	10																																																
12	AC	Cost / part <u>222.80</u>	545	01/08/05	10																																																
13	DC	Close W/O <u>221.22</u> Inspect Level 21	HA	04.08.10	10																																																

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	

**RELEASED**  
04.02.20

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	20958
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.063 x 45°	/		vern	
B 5.500	+/-0.030	5.501	/		vern	
C 0.200	+/-0.030	0.184	/		vern	
D 0.25 x 45°	+/-0.030	0.220 x 45°	/		vern	
E R0.250	+/-0.030	R. 0.250	/		Radius Gauge	
F 0.250	+/-0.010	0.254	/		mic	
G 0.625	+/-0.030	0.624	/		mic	
H 0.375	+/-0.010	0.374	/		vern	
I 0.950	+0.030/0.010	0.946	/		mic	
J 19.000	+/-0.030	19.000	/		TAPE MEASURE	TAPE
K 3.14	+/-0.030	3.10	/		vern	
L 3.28	+/-0.030	3.27	/		vern	
M Ø0.260	+0.005/-0.000	0.260	/		vern	
N Ø0.93	+/-0.030	0.924	/		vern	
O 0.30	+0.030/-0.000	0.300	/		Depth mic	
P 23.750	+/-0.030	23.750	/		TAPE MEASURE	
Q 7.375	+/-0.030	7.380	/		vern	
R 4.250	+/-0.010	4.270	/		vern	
S 2.000	+/-0.030	1.992	/		vern	
T 9.000	+/-0.010	9.040	/		vern	
U 9.000	+/-0.010	9.040	/		vern	
V 0.375	+/-0.010	0.385	/		vern	

Measured by: <i>CP</i>	Audited by: <i>ER</i>	Prototype Approval:	N/A
Date: 04/07/16	Date: 04/07/16	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

RELEASED

04.01.15

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 01, 2004  
01:56 pm

Work Order No : 0020958

Project Name : \*K10008

Project For : WK427

Work Order Type : Main

Main WO Number :

House Part Number : \*K10008

Description : Bearpaw kit 19" x 24"

Manufactured : Yes

Amount Req'd :

Amount Done : 0

Start Date : 06-01-04

Est Finish Date : 06-30-04

Act Finish Date :

Drawings Req'd : No

Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount : 0.00

Order Entry No :

OE Value : 0.00

Est Margin : 0.000%

Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00